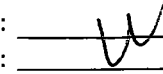


ASAP

Date: Tuesday, 23/09/2008 11:16:36 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	RING
Job Number :	42246		
Estimate Number :	10858		
P.O. Number :		Part Number :	D34075
This Issue :	23/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3407 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	40402	Drawing Revision :	E
	Type :	Material :	
	SMALL /MED FAB	Due Date :	30/09/2008
Written By :		Qty:	40
Checked & Approved By :		Um:	Each
Comment :	Est Rev:A New Issue 05-11-22 JLM Est Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD Est Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M174B0250X4000	17-4 SS Bar .250 X 4.00
-----	----------------	-------------------------



Comment: Qty.: 0.2799 Ft(s)/Unit Total: 11.1972 Ft(s)
 Material: 17-4ph SS 4.00" X .250" THK
 Identify for D3407-5
 Batch: 109543 B8-10-8

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3407
 Dwg Rev: E B8-10-8
 Prog Rev: E



2-Break edges on grinder as per Dwg D3407

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

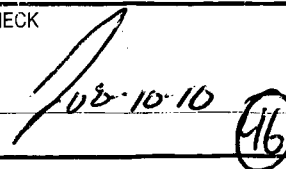


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 11:16:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 42246

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

CARL

PC 08-10-10

(X46)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/10 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

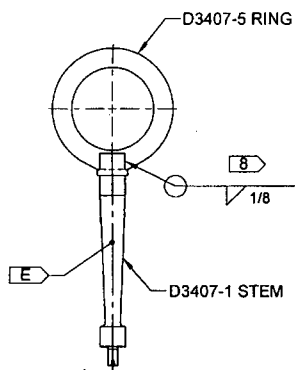
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

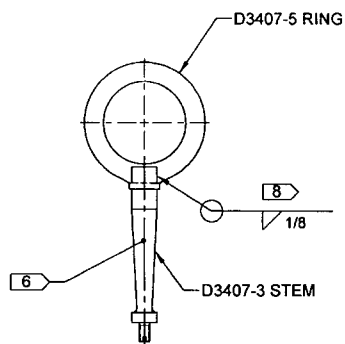
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

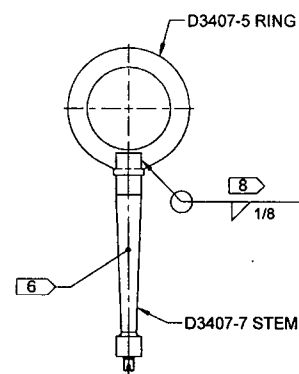
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



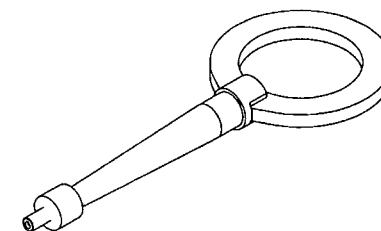
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING



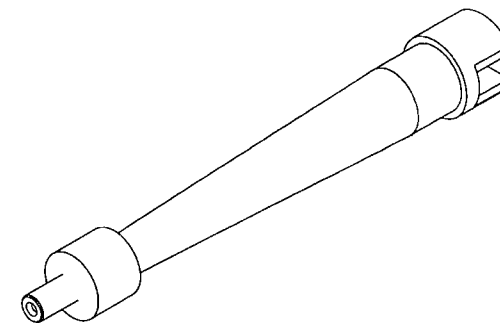
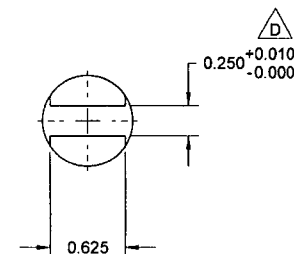
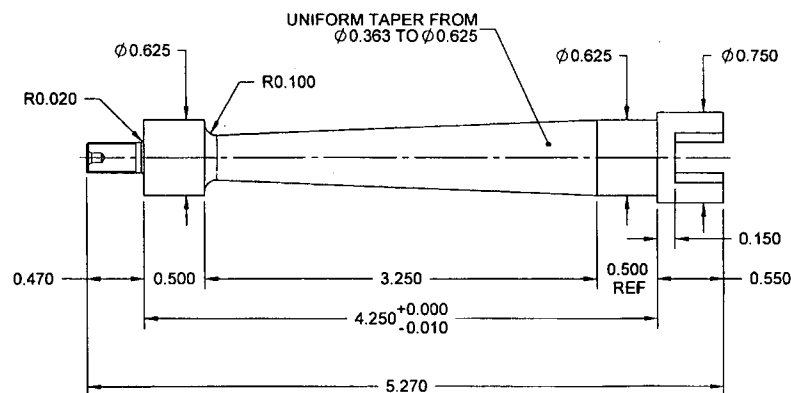
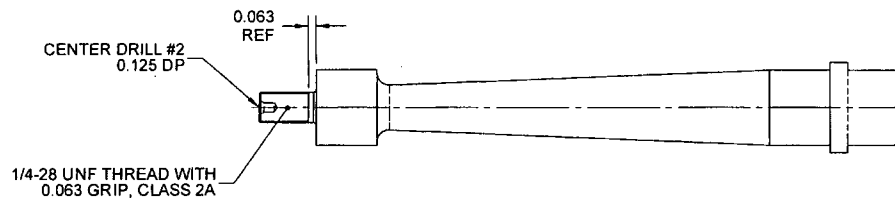
RELEASED

W02246

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 8 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		
<div><div>DART AEROSPACE USA, INC.</div><div>PORT HADLOCK, WA</div></div>			
DRAWING NO. D3407		REV. E	
TITLE TOW RING		SHEET 1 OF 5	
		SCALE	
		NTS	
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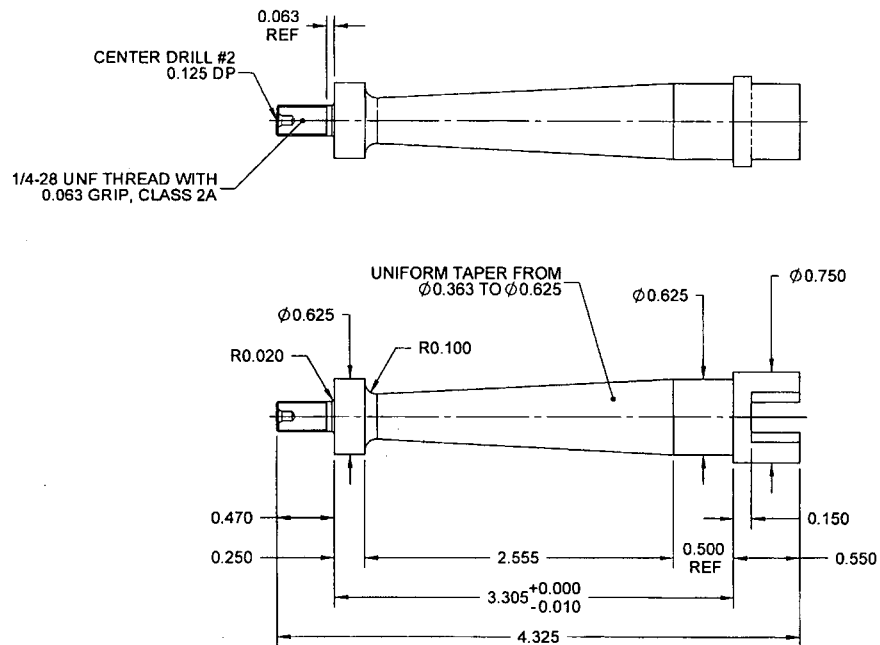
D3407-1 STEM

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

RELEASED

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 2 OF 5
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DE APPR.		TOW RING	NTS
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D3407-3 STEM

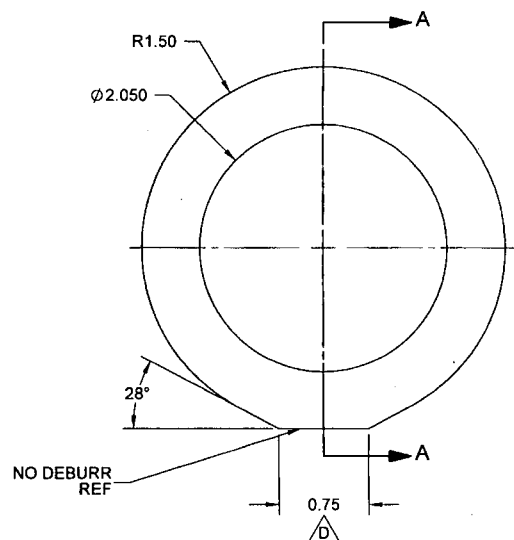
NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

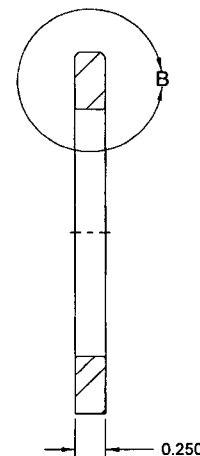
42246

RELEASED
08-08-01 RAB

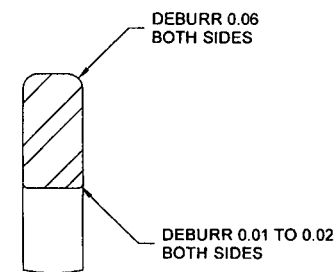
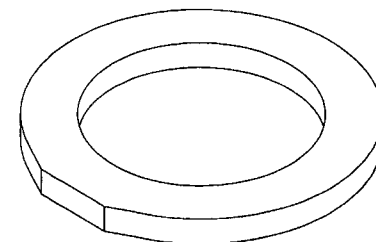
DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-06-01-18

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

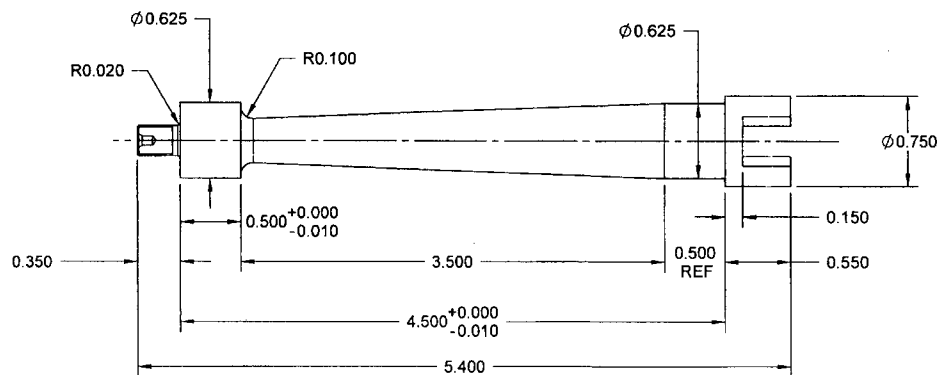
Handwritten: N/A 42246

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	1/18	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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8 7 6 5 4 3 2 1

0.063
REF
CENTER DRILL #2
0.125 DP






1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



D3407-7 STEM

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

RELEASED

DESIGN	AJS	DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

